

Work Order ID 69436

Wednesday, May 11, 2011 10:04:40 AM

Page 1

Item ID: D2327-3

Accept

Revision ID:

Item Name: Spacer Bushing

Start Date: 5/11/2011 Start Qty: 24.00

Required Date: 5/16/2011 Req'd Qty: 24.00

Reference:

Approvals:

Process Plan:

Date: 11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2327

Rev D

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn per Folio FA232 and Dwg D2327 ☐ Debur

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

ASAP



Setup Start

Stop

Cust Item ID:

Customer:

24 ϕ

11/5/11

24 ϕ

11/5/11






24 ϕ



11.5.11






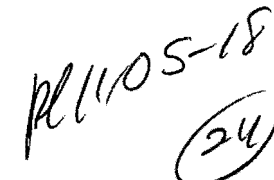
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Item ID: D2327-3 Accept  Setup Start 
Revision ID:
Item Name: Spacer Bushing Stop 
Start Date: 5/11/2011 Start Qty: 24.00  Cust Item ID:
Required Date: 5/16/2011 Req'd Qty: 24.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: _____ <i>AS Basket cell</i> Memo *****STOCK IN BASKET CELL*****	0.00 0.00							<i>11-05-18</i>  
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/5/18</i>  <i>11-05-18</i> 

Picklist Print

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Work Order ID: 69436



Parent Item: D2327-3



Parent Item Name: Spacer Bushing


Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP F05.11.02 Removed 303 SS KJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375  304 ROUND BAR 0.375		Purchased	No			100	f	55.2100	0.1563	3.948632			



SA 11/5/17

Location

Loc Qty

Loc Code

MAT029

55.21

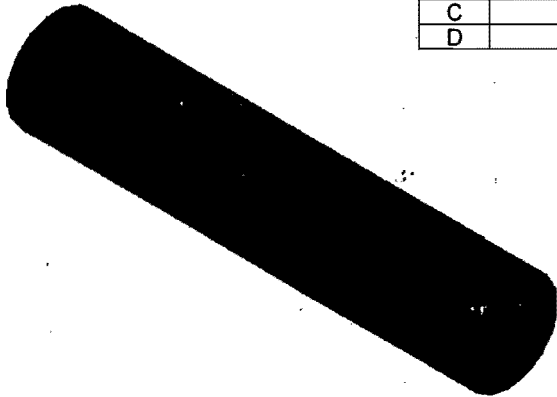
117130

55.21

3.4 PF



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED CH	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	

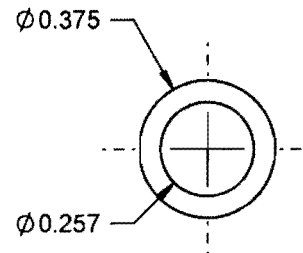
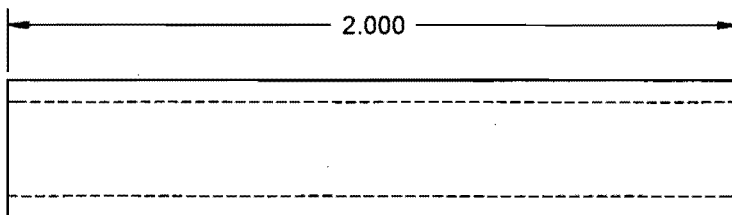


RELEASED

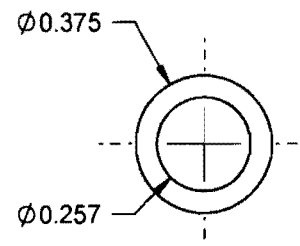
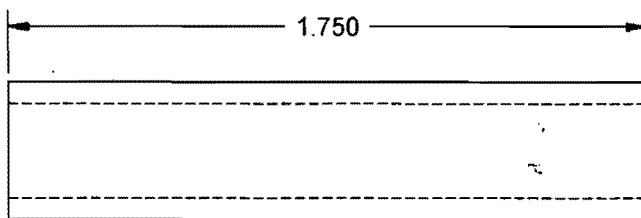
06.11.14

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69434

PS11-05-4



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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